

DUPLICATE

Dart Aerospace Ltd.

Date: Friday, 6/1/2007 1:02:30 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 32738	
Estimate Number : 12786	
P.O. Number : <i>NIA</i>	Part Number : D35645
This Issue : 6/1/2007	Drawing Number : D3564 UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>NIA</i>	Drawing Revision : <i>PH</i> <i>07.07.12</i>
Previous Run : 31420	Material : <i>NIA</i>
Written By : _____	Due Date : 6/8/2007
Checked & Approved By : _____	Qty: 20 Um: Each
Comment : Est Rev:A New Issue 07-03-08 ec	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 1.1099 sf(s)/Unit Total : 22.1970 sf(s)
M304S16GA Stainless steel sheet 0.063" thick
Batch: *M103961* *M101813*

PH *07-07-19*

2.0	WATER JET	"FLOW WATER JET
-----	-----------	-----------------



Comment: FLOW WATER JET
1-Cut as per Dwg D3564 *** (D3564-SF) *** *PH* *07.07.12*
Dwg Rev: *C*
Prog Rev: *C*
PH *07-07-19*
2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

PH *07/07/19* *(Signature)*

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
Deburr if necessary
Form on Brake as per Dwg D3564 using Jigs DT *3156* and DT *3179*
Form Joggle as per Dwg D3564 on brake using Jig DT

SAV *07/07/19* *(Signature)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/07/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/07/03	5	Toggle was made by error						

NOTE: Date & initial all entries

Date: Friday, 6/1/2007 1:02:30 PM
User: Kim Johnston

Process Sheet

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Drawing Name: WEARSHOE

Job Number: 32738

Part Number: D35645

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

En 07/07/20 ^{counter} (23)

7.0

POWDER COATING

POWDER COATING



M 104846



(23x)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M-L 07/07/20

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



M 07 07 21



(23)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



(23x)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FP-14

M-L 07/07/23

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(23)

Comment: FINAL INSPECTION/W/O RELEASE

R 07/07/23

Job Completion



U 07-07-23

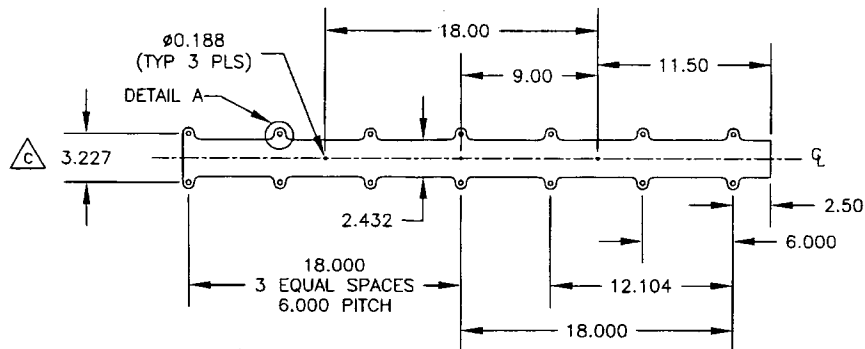
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

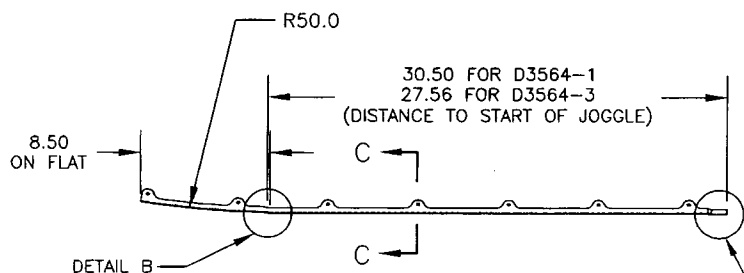
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

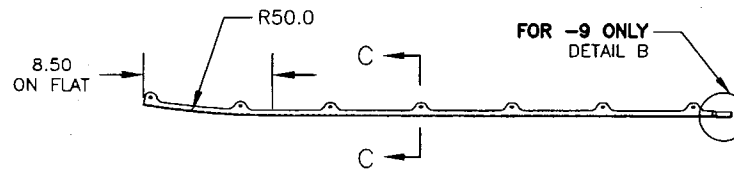
NOTE: Date & initial all entries



D3564-1F FLAT PATTERN



D3564-1/-3 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-9/-11 BENDING DETAIL
(MAKE FROM D3564-1F)

FOR -1 ONLY DETAIL B

2059B HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308



D3564-1/-3/-9/-11 WELDING DETAIL

RELEASED
07-06-28-11

D3564-1/-3/-5/-7/-9/-11/-13 WEARPLATE NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) PART IS SYMMETRICAL ABOUT CENTERLINE

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C	07.04.17	MOVE TAB OUTBOARD, DETAIL A
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.12.18	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD. HAMMERSBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3564
DATE		TITLE WEARSHOE
07.04.17		SCALE 1:8

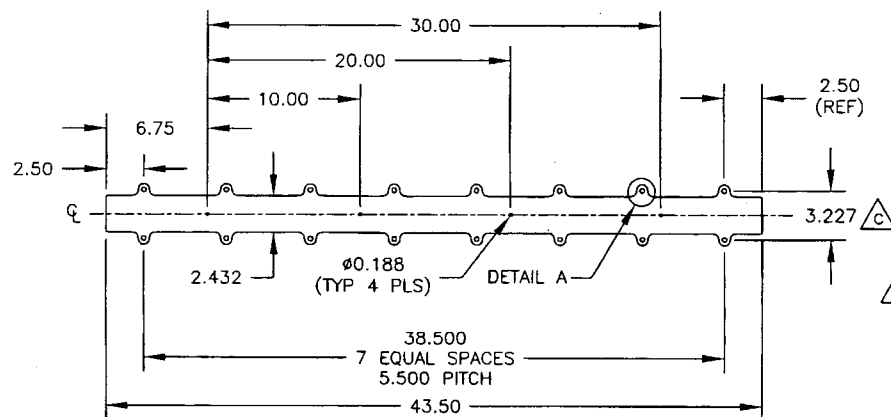
REV. C

SHEET 1 OF 2

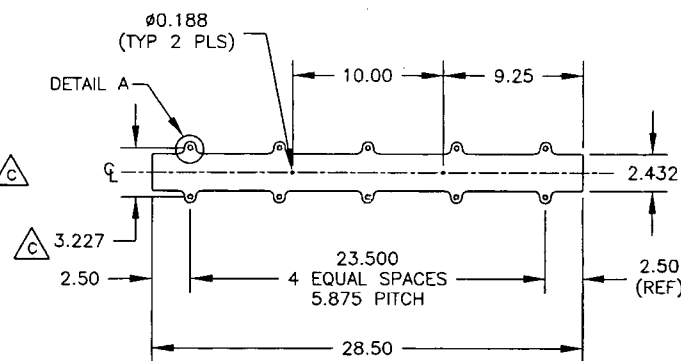
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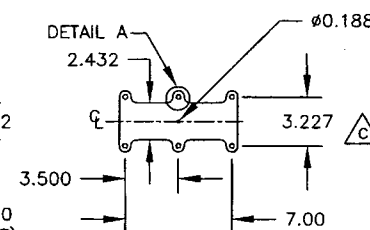
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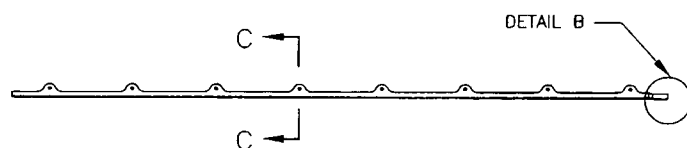
D3564-5F FLAT PATTERN



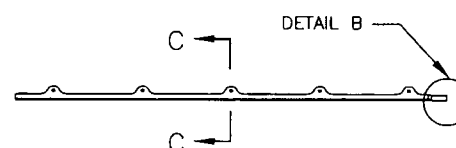
D3564-7F FLAT PATTERN



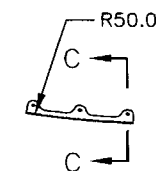
D3564-13F FLAT PATTERN



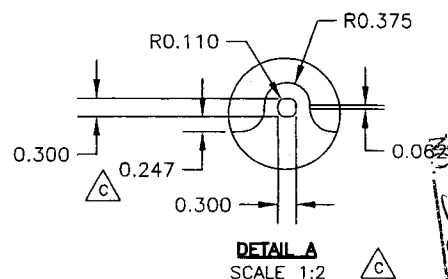
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



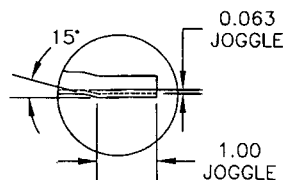
D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



DETAIL A
SCALE 1:2



DETAIL B
SCALE 1:2



SECTION C-C
SCALE 1:2

RELEASED
07.06.2017

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CHECKED
DATE
07.04.17

DRAWN BY
APPROVED

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DRAWING NO.
D3564
TITLE
WEARSHOE

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REV. C
SHEET 2 OF 2
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